

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022712**Date Inspected:** 16-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Lin, CWI Wang Jun.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14W

PCMK: TR3003TR1-001

Weld No: 016

Welder: 045240

WPS-B-T-2233-ESAB

Components; OBG 14W

PCMK: TR3008TR2-001

Weld No: 021

Welder: 067876

WPS-B-T-2233-ESAB

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Components; OBG 14W
PCMK: SEG3020Y
Weld No: 014
Welder: 201215
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhong Lin, CWI Sun Tian Liang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14W
PCMK: SEG3020BB
Weld No: 056
Welder: 067829
Repair No, B-WR20713
WPS-345-SMAW-4G(4F)-FCM-Repair-1

Components; OBG 14W
PCMK: SEG3020B
Weld No: 029
Welder: 069841
WPS-B-P-2214-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Submerged Arc Welding (SAW) process.
ZPMC QC is identified as Zhong Lin, CWI Sun Tian Liang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14W (see photo below)
PCMK: SEG3020*
Weld No: 008
Welder: 045210
WPS-B-T-223(2)1T-ESAB-1

This Caltrans QA Inspector during random observation at ZPMC noted that back gouging was being performed using the Carbon Arc Cutting (CAC) process for the Complete Joint Penetration weld on TR3001TR-001-013. Also noted at this location was ZPMC grinding this back gouge area to a bright metal finish in preparation for the welding process as outlined in the contract documents. (see photo below)

This Caltrans QA Inspector observed ZPMC performing match drilling in OBG, Rib Stiffener Plates, X4000 ~

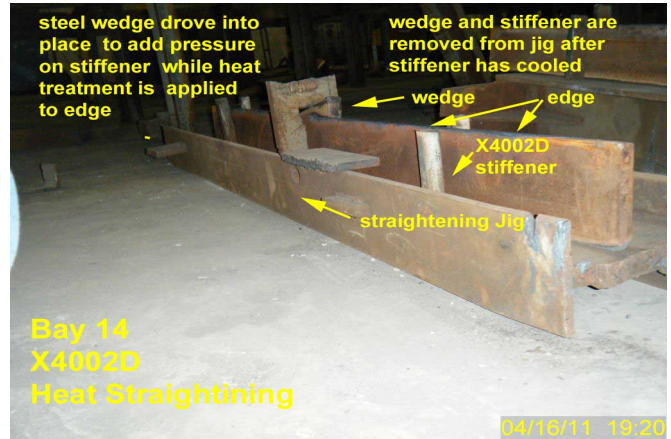
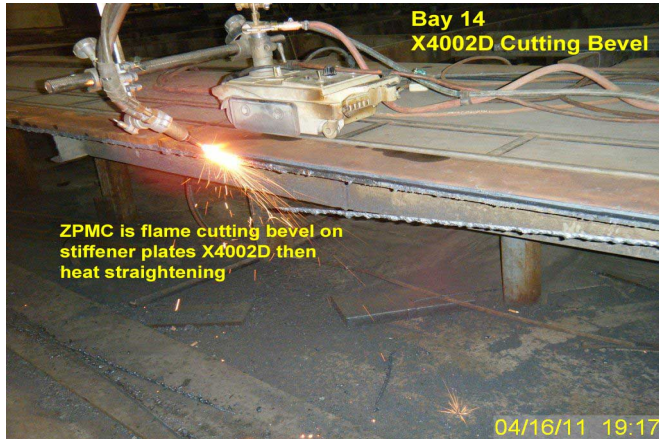
WELDING INSPECTION REPORT

(Continued Page 3 of 3)

X4066.

This Caltrans QA Inspector observed ZPMC performing flame cut beveled edge on stiffeners X4002D then heat straightening these stiffeners using the guide lines on form HSR-1-10246. (see photos below)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

"No relevant conversations."

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer